

Date: Wednesday, 1/23/2008 12:06:41 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 36944
 Estimate Number : 13031

P.O. Number :
 This Issue : 1/23/2008 S.O. No. :

Prsht Rev. : NC

First Issue : / / Type : SMALL /MED FAB

Previous Run : 35845

Written By : 

Checked & Approved By : 

Comment : Est Rev:A New Issue 07-09-27 DD verified by: EC
 Est Rev:B ECN 1113P 08-01-22 DD

Drawing Name : AFT BASE

Part Number : D36513

Drawing Number : D3651 REV.B U/R

Project Number : N/A

Drawing Revision : B U/R

Material :

Due Date : 2/29/2008

Qty: 2 Um: Each

POSITIVE
RECALL

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description:

1.0

M304S26GA

304/316 0.018 SHEET



Comment: Qty.: 0.4977 sf(s)/Unit Total: 0.9954 sf(s)

304/316 SS sheet 26 ga (0.018" thick)

Batch: 105592 HB 8-2-1

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3651

Dwg Rev: B HB 8-2-1

Prog Rev: B

2-Deburr if necessary HB 8-2-1

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE HB 8-2-1

4.0

QC2

SECOND CHECK



Comment: SECOND CHECK HB 8-2-1

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3651 HB 8-03-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/23/2008 12:06:41 PM

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Drawing Name: AFT BASE

Job Number: 36944

Part Number: D36513

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING

U 0802.04



Comment: INSPECT WORK TO CURRENT STEP

APPROVAL

15 08/03/14

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: _____

8.0

QC21

FINAL INSPECTION/W/O RELEASE



SCAP.

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 080314

POSITIVE RECALL

EFFECTIVE 08-11-31 AUTH U

RELEASED _____ DATE _____

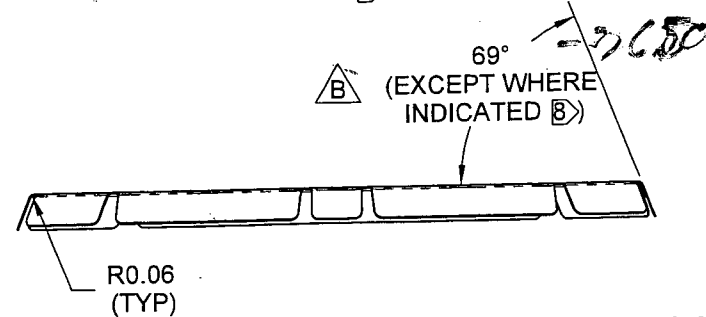
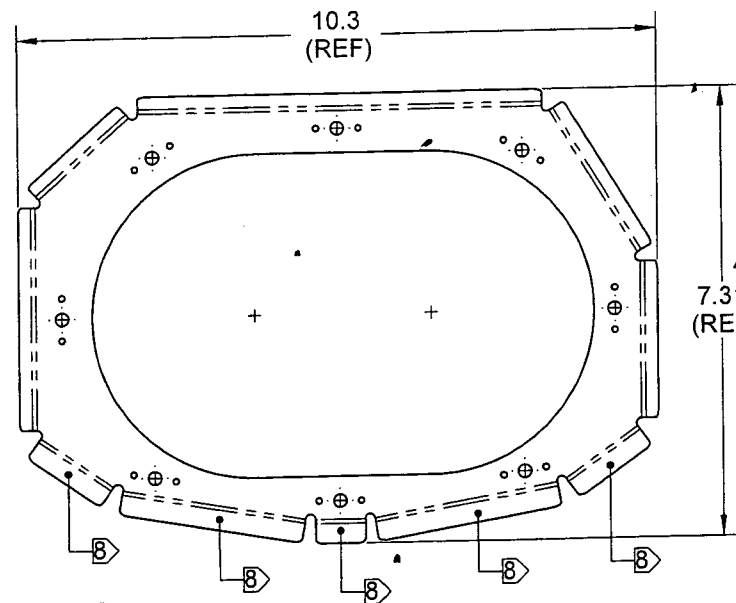
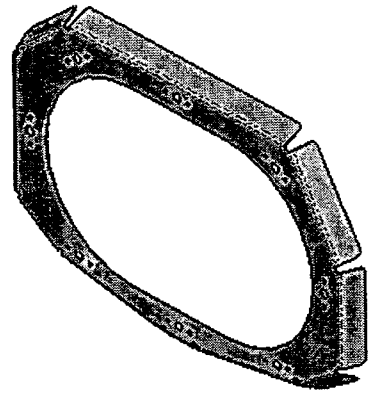
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

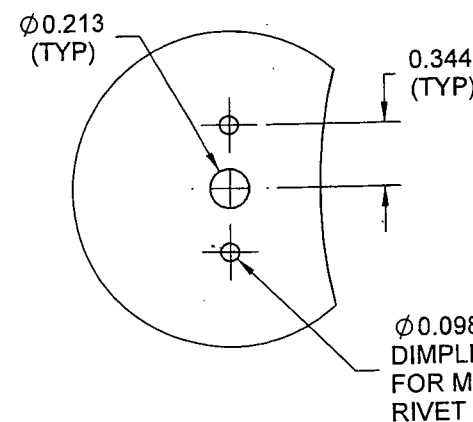
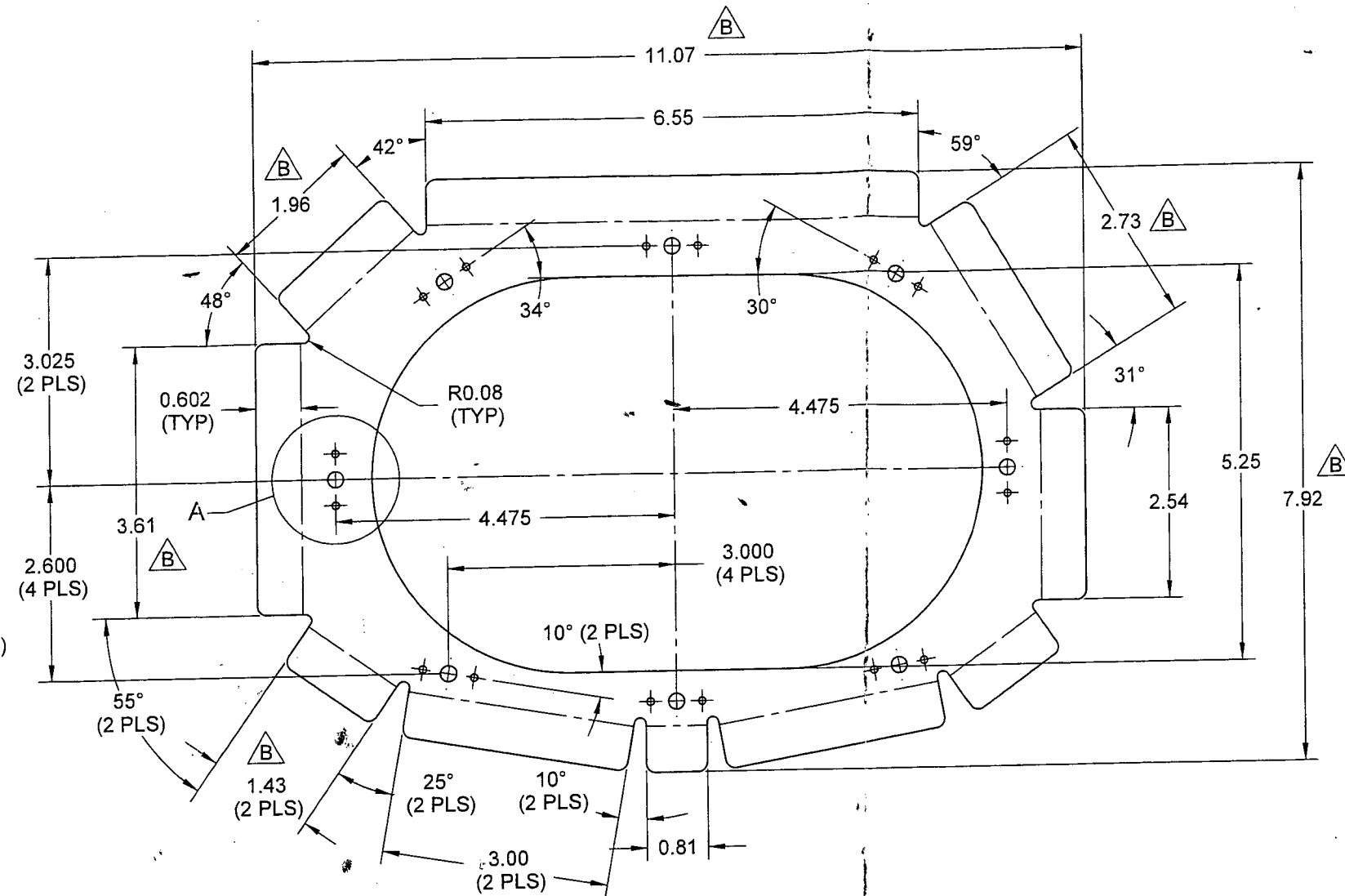
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3651-3 BASE
(MAKE FROM D3651-3F FLAT PATTERN)

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.27 lbs
 - 8) BEND TO 55° WHERE INDICATED



DETAIL A

D3651-3F FLAT PATTERN

PRELIMINARY ISSUE

UE 08.01.18

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	UE	DRAWING NO.	REV. B
MFG. APPR.	MFG	D3651	SHEET 4 OF 9
APPROVED	MD	TITLE	SCALE
DE APPR.		AFT BASE ASSEMBLY	1:2
DATE	08.01.07	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

